

5/44

DART AEROSPACE LTD	Work Order:	24641
Description: Crossbolt Spacer	Part Number:	D2743
Dwg: D2743 Rev. B	Qty:	197 200
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.10.21	200
2	MC	Machine as per Folio FA202 and Dwg D2743 Material: 6061-T6 (WW-T-700/6) Ø0.625 » x 0.065" wall (M6061T6T0.625W.065) Identify for D2743	S.G	05/11/01	200
3	QC2	Inspect parts as they come off the machine Identify as D2743	S.G	05/11/03	200
4	QC8	Second check	me	05/11/03	200
5	ST	Identify and Stock	A	05/11/07	197 ^{CL}
6	AC	Cost / part: <u>.78</u>	S 45	05-11-00	197
7	DC	Close W/O , 85 Inspect Level 21	Q	05/11/09	197

Rev	Date	Change	Revised By	Approved
A	98.09.10	New issue	DS/CP	
B	99.01.04	Drawing to Rev. B	DM	
C	99.11.02	Re-format, Outside contract	EC	
D	02.03.07	Now made in house	NG	
E	05.04.13	Reformat; removed tumble and deburr step	KJ/JLM	

RELEASED
05-04-14

15'
15'
15'
15'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/11/09

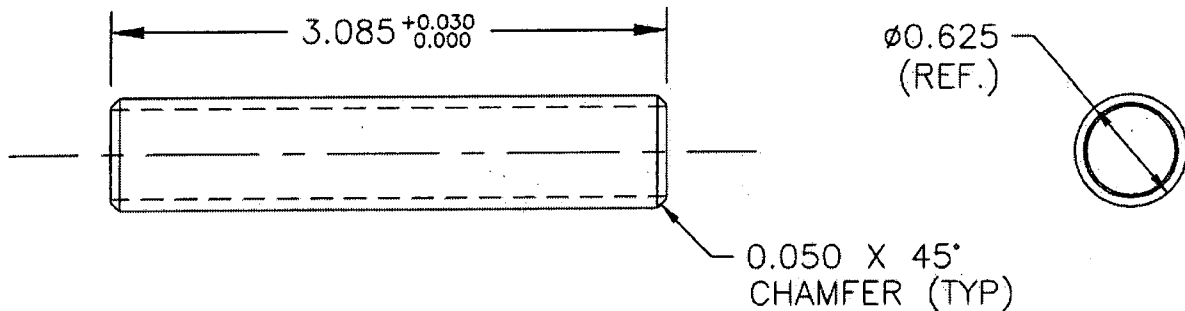
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. 8 SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED
98.12.16 DS



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER

NO. 24641

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 20, 2005
04:09 pm

Work Order No	: 0024641	Department Code:	
Project Name	: D2743	Burden Flags	: NNNNNNNN
Project For	: WK544	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2743	Invoice Number	:
Description	: Crossbolt Spacer	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 200	OE Value	: 0.00
Amount Done	: 0	Est Mark Up	: 0.000%
Start Date	: 10-20-05	Actual Mark Up	: 0.000%
Est Finish Date	: 11-04-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

Date: Wednesday, 11/9/2005 7:16:23 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 24641		
Estimate Number	: 10329		
P.O. Number	:	Part Number	: D2743
This Issue	: 11/9/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2743 REV B
First Issue	: / /	Project Number	:
Previous Run	: 24743	Drawing Revision	: B
	Type	Material	:
	: MACHINED PARTS	Due Date	: 11/16/2005
Written By	:	Qty:	197
Checked & Approved By	:	Um:	Each
Comment	: Est E 05.04.13 Reformat; removed tumble and deburr step KJ/J LM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0625W065	6061-T6 Tube .625 x.065W
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2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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u

Comment: HARDINGE CNC LATHE SMALL
 Machine as per Folio FA202 and Dwg D2743

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

6.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Inspection Level 21

Job Completion



Created in
 M's and
 closed in
 M's

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:42 pm

Work Order No : 0024641
Project Name : D2743
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2743
Description : Crossbolt Spacer
Manufactured : Yes
Amount Req'd : 200
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	3.00	100.00		
Production Cost :	0.00	50.93	100.00	0.00	50.93
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	3.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	50.93	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	50.93			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-50.93)

opening balance
05.11.09

Date: Wednesday, 11/9/2005 8:24:33 AM

User: Linda Lacelle

**INVENTORY ITEMS PICKED
FOR SLIP NUMBER 4**

Project No. :
Customer : Dart Helicopters Services
Part Number : D2743
Job Number : 24641

Drawing Number : D2743 REV B
Drawing Name : CROSSBOLT SPACER
Due Date : / /
Qty : 20
Slip # : 4

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 M6061T6T0625W065 6061-T6 Tube .625 x.065W Available 69.00							
	MAIN			16191		5.60	7.1600 f
	MAIN			18530		5.60	48.0000